



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3319-1**Job Sheet 196909****Part No:** D3319-1**Job Qty:** 12 pcs**Part Name:** Forward Wearplate**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 6/24/19**Job Tracking No:****Due Date:** 7/20/19**Created By:** Kimberley Guerin**Type:** Stock**Description:**

Note: IPP: B 05.10.14 Added step 9, dwg rev B KJ/EC IPP Rev:C Now on Waterjet 06-10-26 JLM IPP REV:D
17.10.25 AS PER DWG REV.D DD VERF:JFS

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier		
100	Waterjet - Flow - 1	12 pcs		7/20/19	0.17	1.25	Waterjet - Flow		JRB 7/11/19
110	QC 2	12 pcs		7/20/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

Plex 6/24/19 4:06 PM Dart.Guerin.Kimberley

120	QC 8	12 pcs	7/20/19	0.00 0.00	QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
140	Small Fab - Brake NC - B4B	12 pcs	7/20/19	0.25 0.87	Small Fab - Brake - 1 - B4B	
					Small Fab - Brake - 2 - B4B	
					Small Fab - Brake - 3 - B4B	
150	QC 5	12 pcs	7/20/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
160	Automated Welding - B4B	12 pcs	7/20/19	0.00 3.08	Automated Welding - 1 - B4B	
170	QC 10	12 pcs	7/20/19	0.00 0.00	QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	
					QC 10 - 43	
					QC 10 - 50	

JTB 7/1/19

DAS
40
9-89

JUL 1 1 2019

DAS
30
9-89

JUL 3 1 2019

DAS
40
9-89

JUL 3 1 2019

M/V

EL

180	QC 5	12 pcs	7/20/19	0.00 0.00	QC 10 - 58	
					QC 10 - 9	
					QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	K
					QC 5 - 30	
					QC 5 - 40	
190	Spray Paint - 2 - B4B	12 pcs	7/20/19	0.00 2.00	Spray Paint - 1 - B4B	AS 19-8-2
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
200	QC 3	12 pcs	7/20/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
210	Packaging 3-1 - Stock - B4B	12 pcs	7/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	

				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	EP-001
				Packaging 3 - 16 - B4B	ML 14-8-14
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - SA	12 pcs	7/20/19	0.00 0.00	QC 21 - SA - 21	PAS 21
				QC 21 - SA - 70	9-55
				QC 21 - SA - 53	

AUG 16 2019

Part Op **100** - 1-Cut as per Dwg D3319 Dwg Rev: _____ Prog Rev: _____ 2-Debur if necessary

Descriptions: **110** - (QC2- Inspect parts off machine FAI/FAIB)

120 - QC8- Inspect parts - second check)

140 - (Form as per dwg) 1- Form using DT8326 & DT8261 as per Dwg D3319Rev: _____ 2- Form flat on press using DT8776 block

150 - QC5- Inspect part completeness to step on W/O)

160 - 8259 HARDCOAT B: _____

170 - (QC10- Inspect visual per QSI004- ground welds)

180 - (QC5- Inspect part completeness to step on W/O)

190 - Spray Paint / NDT Room) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURE COATING AS PER DWG NOTE 9 SHEET ONE. BATCH: 5200412

200 - (QC3- Inspect Part Finish)

210 - (Identify as per dwg & Stock Location: _____)Identify on inside surface using a permanent fine point marker with the following: TCCA-PDA, Dart Aerospace Ltd. P/N: D3319-1, B/N: BXXXXX For Product Eligibility see PDA05-18 and Stock Location: _____

220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	7.5360 sf (.628 ea)	100-Waterjet - Flow - 1	5175009 x3
				5188581 x6
				5132620 x4
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	8	320	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate	4.980inches $\pm$ 0.030	5.010 4.950	4.979	
2	Wearplate	1.600inches $\pm$ 0.010	1.610 1.590	1.600	
3	Wearplate	2.660inches $\pm$ 0.010	2.670 2.650	2.665	
4	Wearplate	3.190inches $\pm$ 0.010	3.200 3.180	3.197	
5	Wearplate	3.563inches $\pm$ 0.010	3.573 3.553	3.559	
6	Wearplate	4.710inches $\pm$ 0.030	4.740 4.680	4.705	
7	Wearplate	0.600inches $\pm$ 0.030	0.630 0.570	0.600	
8	Wearplate	10.576inches $\pm$ 0.010	10.586 10.566	10.575	
9	Wearplate	11.942inches $\pm$ 0.010	11.952 11.932	11.942	
10	Wearplate	18.090inches $\pm$ 0.030	18.120 18.060	18.090	
11	Wearplate	0.316inches + 0.006 - 0.001	0.322 0.315	317	
12	Wearplate	0.546inches $\pm$ 0.010	0.556 0.536	550	
13	Wearplate	0.316inches + 0.006 - 0.001	0.322 0.315	317	
14	Wearplate	0.670inches $\pm$ 0.010	0.680 0.660	671	
15	Wearplate	0.190inches + 0.005 - 0.001	0.195 0.189	0.191	
16	Wearplate	3.815inches $\pm$ 0.010	3.825 3.805	3.810	
17	Wearplate	16.100inches $\pm$ 0.010	16.110 16.090	16.100	

Plex 6/24/19 4:06 PM Dart.Guerin.Kimberley



Container No: S197300



Part: D3319-1

Job No: 196909

Serial No/Batch: S197300

Revision: D

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7

CANADA

TEL: 1 813 632-5200

Email: sales@dartaero.com

www.dartaerospace.com

Date: 07/11/19